

Date: Monday, 27/11/2006 11:47:40 AM
User: Linda Lacelle

Process Sheet

| | |
|---|--|
| Customer : CC-DAR01 Dart Aerospace Ltd. | Drawing Name : D2582 |
| Job Number : 29706 | |
| Estimate Number : 10804 | |
| P.O. Number : | Part Number : D2582 |
| This Issue : 27/11/2006 S.O. No. : | Drawing Number : RTN 539 |
| Prsht Rev. : NC | Project Number : |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : |
| Previous Run : 00015 | Material : |
| Written By : | Due Date : 04/12/2006 Qty: 1 Um: Each |
| Checked & Approved By : | |
| Comment : | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|------------------------------|
| 1.0 | QC5 | INSPECT WORK TO CURRENT STEP |



Comment: INSPECT RTN 539

06/11/27 (1)

| | | |
|-----|-------|------------------------|
| 2.0 | D2582 | Hi-Skid Step Leg Ass'y |
|-----|-------|------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Hi-Skid Step Leg Ass'y
ORIGINAL B/N 27756

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
ID & STK
USING NEW B/N

PV 4/11/28 (1) Post E.

| | | |
|-----|------|------------------------------|
| 4.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8011.29

Date: Wednesday, 6/28/2006 4:18:25 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HI-STEP LEG ASSEMBLY |
| Job Number : 27756 | |
| Estimate Number : 10355 | |
| P.O. Number : N/A | Part Number : D2582 |
| This Issue : 6/28/2006 S.O. No. : N/A | Drawing Number : D2582 REV A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 25395 | Material : N/A |
| Written By : <u>See Comment Below</u> | Due Date : 7/12/2006 |
| Checked & Approved By : <u>06 06 29</u> | Qty: 20 Um: Each |
| Comment : Est Rev: F Removed Manufacturing 05-11-07 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------|--------|
| 1.0 | 27756A | SPACER |
|-----|--------|--------|



Comment: Sub-Component SPACER

| | | |
|-----|--------|----------|
| 2.0 | 27756B | STEP LEG |
|-----|--------|----------|



Comment: Sub-Component STEP LEG

| | | |
|-----|--------|-------------|
| 3.0 | 27756C | STEP SPACER |
|-----|--------|-------------|



Comment: Sub-Component STEP SPACER

| | | |
|-----|--------|-------------|
| 4.0 | 27756D | STEP SPACER |
|-----|--------|-------------|



Comment: Sub-Component STEP SPACER

| | | |
|-----|-------------|-----------------------|
| 5.0 | MS20470AD44 | Rivet, Universal Head |
|-----|-------------|-----------------------|



Comment: Qty.: 22.0000 Each(s)/Unit Total : 440.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4

Rivet

~~118729~~

M19073

53

255

M18729

M100993

CH

| | | |
|-----|-------------|-----------------------|
| 6.0 | MS20470AD45 | Rivet, Universal Head |
|-----|-------------|-----------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5

Rivet

M18461

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|------|--|-----|----------|-----|---------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector | |
| 06-07-31 | 6.1 | Need D2280 picked to complete the Ass'y. Add to estimate permanent change. | | | | | | |
| | | Pick 2x D2280 per Ass'y B27756A | SAD | 06-07-31 | | | | |
| 06-07-31 | 8.0 | Stock } 2x D2379 spacer B27756 I.D. } 4x D2278 B27756 leg. in G.A. as overstock | SAD | 06-07-31 | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---------------------------------|--|-----------------|---------------------------|---------------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 06-07-31 | 7.0 | Upon drilling and replacing rivets in the step Ass'y, holes were ovalized to over tol. R.C. drill bit wander. in on rivet head, and not being centered | UP 06-08-04 per Q51042 | destroy: replace: 2x D2280 B27756A 1x D2379 B27756 2x D2278 B27756 3 Ass'y Incomplete No more D2322 | SAD 06-07-31 | 06-07-31 | UP 06-08-04 per Q51042 | 06-07-31 |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 06/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:18:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 27756

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

SAD

06:07:30

17

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA26

L.E. 06.8.1

17

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/10

17

Job Completion



C206108103

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

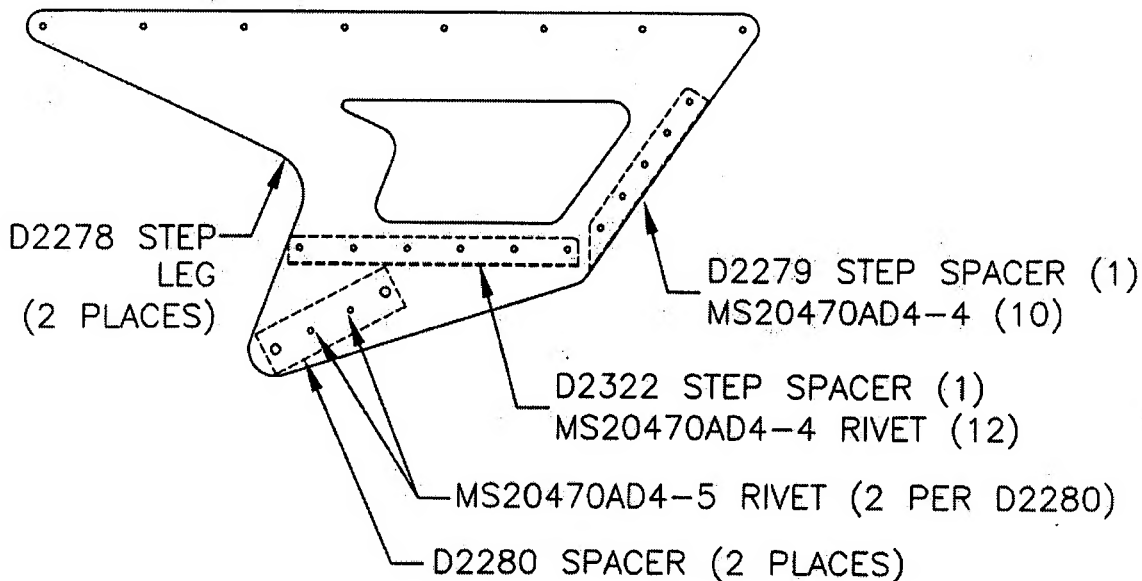
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|---------------------|-----------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>#</i> | APPROVED <i>#</i> | DRAWING NO. D2582 | REV. A SHEET 1 OF 1 |
| DATE 01.10.05 | | TITLE STEP LEG ASSEMBLY | SCALE 1:5 |
| A | 01.10.05 | NEW ISSUE | |

| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|-------------|
| 2 | D2278 | STEP LEG |
| 1 | D2279 | STEP SPACER |
| 2 | D2280 | SPACER |
| 1 | D2322 | STEP SPACER |
| 22 | MS20470AD4-4 | RIVET |
| 4 | MS20470AD4-5 | RIVET |



D2582

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
01-10-16 SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27756

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